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~~22 JAN~~
D117-840-011
Job Sheet 187444



Part No: D117-840-011

Job Qty: 2 pcs

Part Name: BK117/EC145 Bearpaws with Wearplates



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: ~~1/21/19~~ *DEC*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 13-04-01 JLM VERIED BY:DD IPP REV:B 13.05.28 PER IIN D117-840
REV.A DD VERF:JLM IPP REV:C 15.03.30 PER REV B JLM VERIFIED BY:DD IPP REV:D 16.02.23 PER IIN
REVC DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	Packaging 1 - Pick Kit	2 pcs	1/21/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

DEC 10 2018

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation			Disposition		
Container No: S136424 Part: D117-840-011 Job No: 187444 Serial No/Batch: S136424 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH13-18- Issue 1, FAA STC SR0331 DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
170	QC 4	2 pcs	1/21/19	0.00 0.00	QC 4 - 16	
					QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
180	Packaging 3-1 - Stock - B4B	2 pcs	1/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
185	DC - 1 - B4B	2 pcs	1/21/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
190	QC 21 - FG	2 pcs	1/21/19	0.00 0.00	QC 21 - FG - 16	
					QC 21 - FG - 21	

Part Op 170 - (QC4- 100% Inspect kits for completeness)

Descriptions: 180 - Identify and pack for shipping as per PPP D117-840-011

185 - Photocopy bluefile & type labels per PPP D117-840-011 CHG 003

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				

Part / Item	Component Name	Quantity	Operation
AN4C11A	Bolt	24 Ea (12 ea)	160-Packaging 1 - Pick Kit
AN4C17A	Bolt	16 Ea (8 ea)	160-Packaging 1 - Pick Kit
D2274	Radius Block	16 Ea (8 ea)	160-Packaging 1 - Pick Kit
D3456-1	Washer	16 Ea (8 ea)	160-Packaging 1 - Pick Kit
D4012-3	Cushion	8 Ea (4 ea)	160-Packaging 1 - Pick Kit
D5377-1	Bearpaw	4 Ea (2 ea)	160-Packaging 1 - Pick Kit
D5378-041	Bearpaw Wearplate Assembly	4 Ea (2 ea)	160-Packaging 1 - Pick Kit
D5379-1	Bearpaw Clamp	8 Ea (4 ea)	160-Packaging 1 - Pick Kit
MS21043-4	Nut	40 Ea (20 ea)	160-Packaging 1 - Pick Kit
NAS1149D0463J	Washer	24 Ea (12 ea)	160-Packaging 1 - Pick Kit

Container

5099546
5093740
5130330
5079335
5046542
5124304
5110357
5124307
5092790
5092780

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
160-Packaging 1 - Pick Kit	AN4C11A	24	121	0
	AN4C17A	16	45	0
	D2274	16	444	0
	D3456-1	16	239	0
	D4012-3	8	69	0
	D5377-1 453	4	7	0
	D5378-041 665	4	6	0
	D5379-1 543	8	18	0
	MS21043-4	40	883	0
	NAS1149D0463J	24	4,036	0

Part Specifications

Specifications could not be found.

Plex 12/4/18 1:12 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



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Other/Details:					

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-840-011 <i>Bearpaw Installation</i>	27.7 lb 12.6 kg	0.0 in 0.0 mm	0.0 lb-in 0.0 mm-kg	204.1 in 5200 mm	5653 in-lb 65,520 mm-kg

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
8	D3456-1	WASHER
4	D4012-3	CLAMP CUSHION (REPLACES D4012-1)
2	D5377-1	BEARPAW (REPLACES D4796-1)
2	D5378-041	BEARPAW WEARPLATE ASSY (REPLACES D4798-041)
4	D5379-1	BEARPAW CLAMP (REPLACES D4799-1)
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
12	NAS1149D0463J	WASHER

